

229
5/20

DART AEROSPACE LTD	Work Order:	23055
Description: Base Plate Panel	Part Number:	D3333-1
Dwg: D3333 Rev. B page 1	Qty:	15
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.04.19	15
2	MV	Cut blanks: 9.00" x 4.00" x 0.750" thick Material: AISI 4140 Steel Minimum yield tensile strength: 100ksi (M4140N-B0.750x04.000) Identify for D3333-1 Batch: M16989	CF	05/05/06	15
3	MV	Machine as per Folio FA478 and Dwg D3333 Identify as D3333-1 Dwg Rev. SS Folio Rev. A	1SD	05.05.17	15
4	QC2	Inspect parts as they come off the CNC machine	1SD	05.05.17	16
5	QC8	Second check	B	05.05.17	15
6	MFA	Deburr	SD	05.05.17	15
7	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Ensure to mask threaded holes	FC	05.06.14	15
8	QC3	Inspect Powder Coat	ML	05.06.14	15
9	ST	Identify and Stock	CPL	05/06/14	15
10	AC	Cost / part: 62.91	AR	05/06/15	15
11	DC	Close W/O 63.81 Inspect Level 21	KJ	05.06.16	15

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	
B	05.02.08	No longer made inhouse	KJ/RF	
C	05.04.15	Made in-house	KJ/JLM	

RELEASED
05.04.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

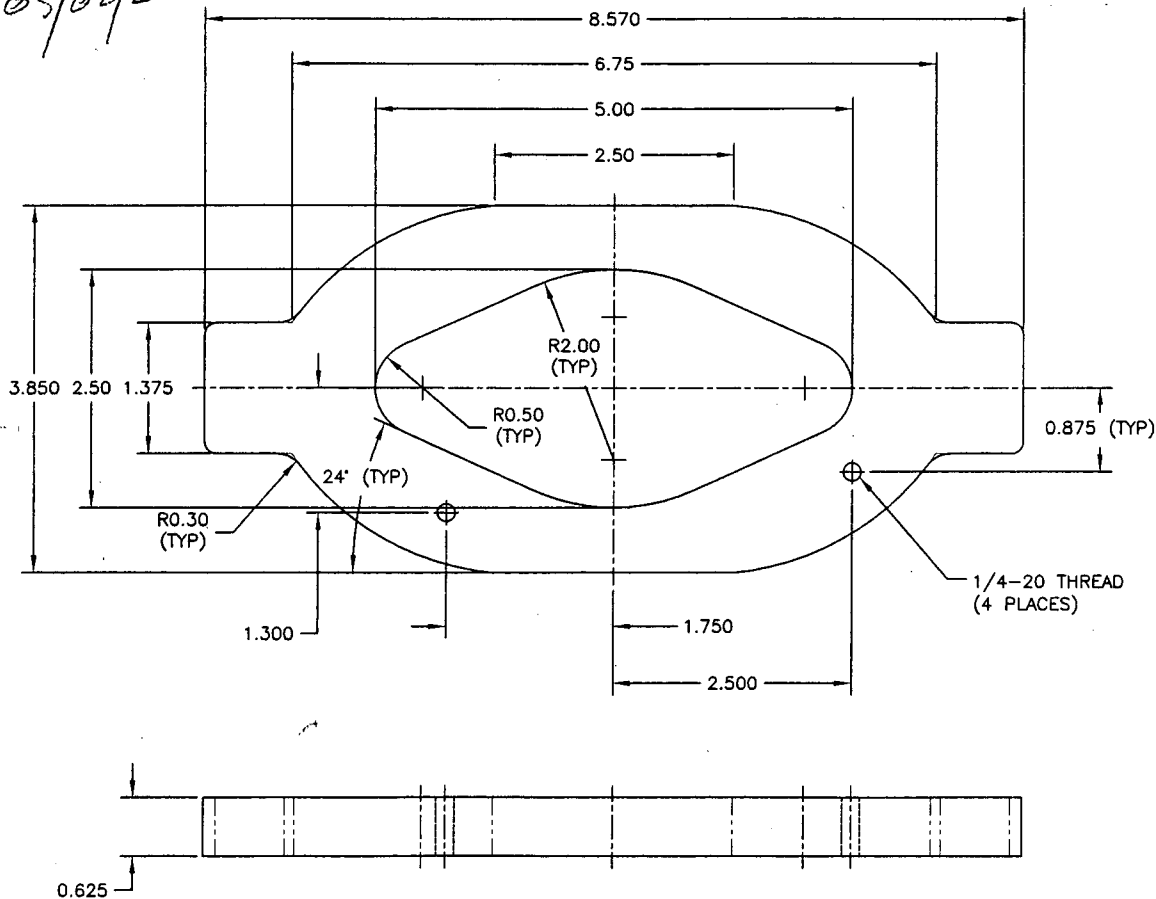
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN R	DRAWN BY R	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED R	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18	TITLE PLATE	SCALE 1:2	
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED
05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B)
MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005-4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

WORK ORDER
NO. 23055

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No : 0023055
Project Name : D3333-1
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3333-1
Description : Base Plate Panel
Manufactured : Yes
Amount Req'd : 15
Amount Done : 0
Start Date : 04-12-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

